

## MANUFACTURING METHOD OF TRADEMARK LABEL

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### BACKGROUND OF THE INVENTION

#### Field of the Invention:

The present invention relates to a manufacturing method of trademark label, and more particularly to a manufacturing method of trademark label which can be produced  
10 natural rubber and artificial leather for shoes, bag and cloth.

#### Description of the Prior Art:

Hence, by providing manufacturing method of trademark label made of natural rubber or artificial leather through this invention, it can bring solution to technical  
15 assignment of environment and can also improve quality of the trademark label such as lightening.

### SUMMARY OF THE INVENTION

The purpose of this invention is to prove manufacturing method of trademark  
20 label made of natural rubber or artificial leather through this invention, it can bring solution to technical assignment of environment and can also improve quality of the trademark label such as lightening of the product.

In making trademark label of this invention, process of making rubber sheet combining natural rubber elements, process of cutting rubber sheet based on trademark label design, process of applying primer on glue part of cut trademark label and drying in high temperature for 5 minutes, process of applying binder on top of applied/dried part of trademark label primer, process of gluing (first gluing process) glue-applied trademark label with artificial leather by inserting in metallic pattern cavity, process of removing unnecessary impurities of trademark label attached (by first gluing process) to artificial leather, process of hot-pressing in 150°C by inserting trademark label impurity is removed to metallic pattern, and process of refrigerating trademark label hot-pressed on artificial leather in about 5°C are all included. And trademark label (1) manufactured as mentioned above can provide unique trademark label attaching trademark label (1) on artificial leather (2) and natural rubber can be attached to artificial leather so that with its lightness, when it is used on out soles such as marathon shoes it can reduce the weight of the shoes and can possibly bring record break effect and when it is burnt, it does not produce environmentally-harm substances such as dioxin therefore it is very effective invention.

## BRIEF DESCRIPTION OF THE DRAWINGS

Figure 1 is a process figure showing method of trademark label (1) and this invention provides in blocks and this provides product which has trademark label made

of natural rubber on upper side of artificial leather (2) as it is shown on sectional diagram of figure 2.

5           To produce trademark label using artificial leather (2) and natural rubber, primer and binder to glue and heat-pressure the artificial leather and natural rubber are very important and impurity removal procedure after adhesion with glue and refrigeration pressing on appropriate temperature must be carried as well.

          Detailed description of production method for trademark label in this present  
10   invention is as followed.

          Produce aluminum metallic pattern based on trademark label (1) designing specified logos and figures requested by demander's design (usually called 'OEM' method).

          And then combine trademark label material mainly consists natural rubber.

15           Namely, main material of rubber sheet produced by natural rubber material organizing trademark label (1) is weight of raw material and;

Natural Rubber about 6,000g,

Styrene Butadiene Rubber; SBR 5,000g,

Nitrile Butadiene Rubber; NBR 4,000g,

20   Zinc Oxide 1,000g,

White Carbon, the color strengthener of natural rubber 6,000g,

Isopropanolamine, the plasticizer 480g,

5 Butyl-p-Cresol(BHT) 100g,

Stearic acid, the stabilizer and plasticizer 150g,

Resin guaiac, the antioxidant 500g,

CaO 2,000g,

Mercaptobenzothiazole 70g,

10 Dibenzothiazyl Disulphide 200g,

Tetramethylthiuram Monosulphide (TS) 10g,

Paraffin series process oil for antipollution and color stability P-1 3,000g,

Sulphur 300g

After roll mixing all these materials in roll mixer and produce rubber sheet out of it.

15 Do air-pressing procedure on rubber sheet produced by natural rubber composite mentioned above and make trademark label (1) through cutting procedure based on logo design of trademark label requested.

For procedure gluing trademark label (1) made of rubber sheet to artificial leather (2), apply 'No 503 Primer' manufactured by 'Keojin Commercial Company' in

Korea and dry it for 5 minutes on high temperature. And then mix 'DS 5109 Binder' manufactured by 'Dongsung Industrial Company' in Korea with CRF hardener weight  
5 ration of 0.5 percent. After that, insert that on cavity of aluminum metallic pattern which has same cavity with trademark label (1) and cover the artificial leather (2) and close the metallic pattern and finally glue it solidly.

After gluing procedure of rubber sheet (trademark label) made of natural rubber elements and artificial leather (2), open metallic pattern and remove all impurities except  
10 trademark label (1) and re-insert it into metallic pattern and hot press on 150°C on both side and go for refrigeration press procedure in about 5°C and draw out completed trademark label (1) from metallic pattern.

Detailed description of manufacturing method of trademark label (1) being attached to artificial leather (2) is shown on following examples.

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### **BRIEF DESCRIPTION OF THE DRAWINGS**

#### **Example**

The trademark label is manufactured using artificial leather and rubber sheet produced with natural rubber element mentioned above.

20 Natural Rubber about 6,000g,

Styrene Butadiene Rubber; SBR 5,000g,

Nitrile Butadiene Rubber; NBR 4,000g,

5 Zinc Oxide 1,000g,

White Carbon 6,000g,

Isopropanolamine 480g,

Butyl-p-Cresol(BHT) 100g,

Stearic acid 150g,

10 Resin guaiac 500g,

CaO 2,000g,

Mercaptobenzothiazole 70g,

Dibenzothiazyl Disulphide 200g,

Tetramethylthiuram Monosulphide (TS) 10g,

15 Paraffin Series Process Oil (P-1) 3,000g,

Sulphur 300g

were roll mixed in roll mixer and produced rubber sheet through vulcanization process.

Trademark label is made through cutting process based on trademark label logo design requested after air-pressing rubber sheet mentioned above.

For procedure gluing trademark label (1) made of rubber sheet to artificial leather (2), apply 'No 503 Primer' and dry it for 5 minutes on high temperature. And  
5 then mix 'DS 5109 Binder' with CRF hardener weight ration of 0.5 percent. After that, insert that on cavity of aluminum metallic pattern which has same cavity with trademark label (1) and cover the artificial leather (2) and close the metallic pattern and finally glue it solidly.

Trademark label made of rubber sheet consisting natural rubber elements is  
10 solidly attached not getting removed from surface of artificial leather and any transformation such as curving of product did not occur.

Trademark label with softness of artificial leather and quality of rubber sheets is visually luxurious and it was totally unique when compared to ordinary trademark label only made of synthetic rubber.

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